

Date: Wednesday, 10/10/2007 11:00:18 AM  
 User: Kim Johnston

## Process Sheet

45

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 205 BEARPAW INSTALLATION KIT (48")  
 Job Number : 35062  
 Estimate Number : 12283  
 P.O. Number : N/A Part Number : D205564011  
 This Issue : 10/10/2007 S.O. No. : N/A Drawing Number : D2521  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : J  
 Previous Run : 32835 Material : N/A  
 Due Date : 11/5/2007 Qty: 5 Um: Each  
 Written By : JA 07/10/10  
 Checked & Approved By : JA 07/10/10  
 Comment : Est F 00.01.20 Changed pick list, MPP 2019, CHG006 EC  
 Est Rev:G 06-08-28 As per Rev E JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



RS 07.10.11

Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D205-564-011 CHG008

6 07/12/05

2.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 13.6500 sf(s)/Unit Total: 68.2500 sf(s)  
 blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6  
 Material: Black UHMW 1"  
 (MUHMWB10)  
 Batch: M106161

DIP 07/11/26

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

(2) Bearpaws Make (1) kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2521

3-Deburr

SF 07/11/27

DIP 07/11/26

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SF 07/11/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/10/2007 11:00:18 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 35062

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 07/11/28

6.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 3.7000 f(s)/Unit Total : 18.5000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2182B055 Rubber Cushion B34777

AS 07/12/04 (X5)

7.0

D2274

Radius Block



Comment: Qty.: 20.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2274 Radius Block B32857

AS 07/12/04 (X5)

8.0

D2529

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2529 Washer B32025

AS 07/12/04 (X5)

9.0

D2947

Clamp



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

8 D2947 Clamp 30386

AS 07/12/04 (X5)

10.0

D3544041

CLAMP



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

CLAMP

Batch: B32864 x 7 B35088 x 13

AS 07/12/04 (X5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 01/12/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/10/2007 11:00:18 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 35062

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

Batch: M106043

AS 07/12/04 (X5)

12.0

AN415A

Bolt



Comment: Qty.: 20.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN4-15A Bolt M104746

AS 07/12/04 (X5)

13.0

AN960JD416

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN960JD416 Washer M105906

AS 07/12/04 (X5)

14.0

MS21042L4

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 100.0000 Each(s)

Nut

Batch: M105054

AS 07/12/04 (X5)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 07/12/05 (X5) (X5)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Loc C

7/12/05

SD (X5)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2 07/12/06

11 07/12/05

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>35062</b>
<b>Description:</b> Bearpaw		<b>Part Number:</b>	<b>D2521</b>
<b>Inspection Dwg:</b> D2521 <b>Rev:</b> J		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	0.261	✓			
B	0.90	0.96	0.927	✓			
C	0.27	0.330	0.300	✓			
D	0.470	0.530	0.500	✓			
E	21.740	21.760	21.75	✓			
F	0.72	0.780	0.752	✓			
G	0.35	0.410	0.377	✓			
H	11.490	11.570	11.500	✓			
I	3.41	3.47	3.440	✓			
J	11.790	11.810	11.800	✓			
K	9.47	9.53	9.500	✓			
L	7.190	7.210	7.20	✓			
M	6.910	6.970	6.937	✓			
N	44.47	44.530	44.480	✓			
O	6.590	6.650	6.625	✓			
P	0.940	0.980	0.945	✓			
Q	18.97	19.03	19.015	✓			
R	0.350	0.410	0.385	✓			
S	0.740	0.780	0.748	✓			
T	0.240	0.280	0.255	✓			
U	0.370	0.410	0.385	✓			
V	0.740	0.780	0.753	✓			
W	0.740	0.780	0.752	✓			

<b>Measured by:</b> DSP	<b>Audited by:</b> JAL	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/11/26	<b>Date:</b> 07/11/26	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	JAL





DESIGN #	DRAWN BY CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. <b>D2521</b>	REV. J SHEET 1 OF 3
DATE <b>06.07.28</b>		TITLE <b>205 BEARPAW</b>	SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35062

RELEASED

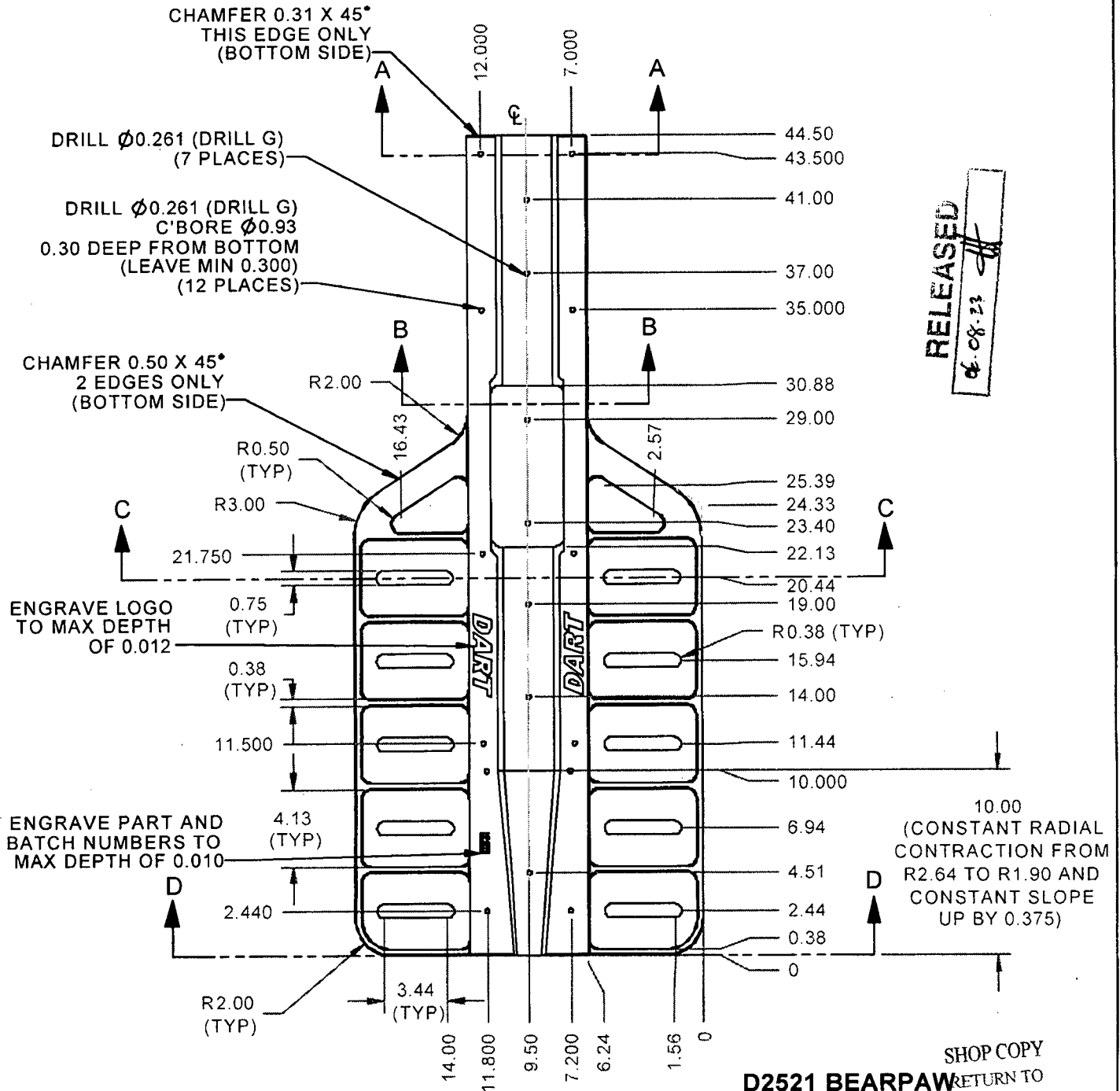
06 08.23 #

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**DART**

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CHECKED CP	APPROVED [Signature]	DRAWING NO. <b>D2521</b>	REV. J SHEET 2 OF 3
DATE <b>06.07.28</b>		TITLE <b>205 BEARPAW</b>	SCALE 1:8

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT  $\varnothing$





**D2521 BEARPAW**

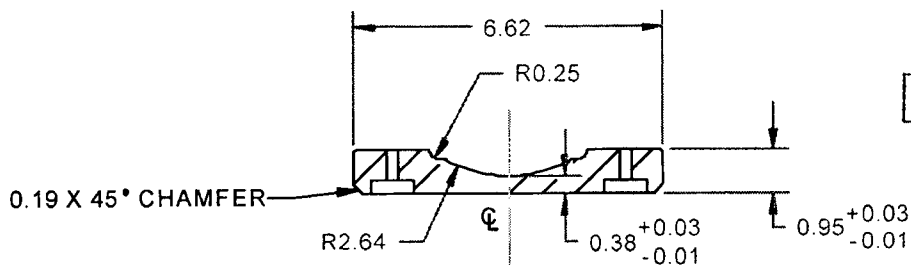
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WORK ORDER  
NO. **35062**

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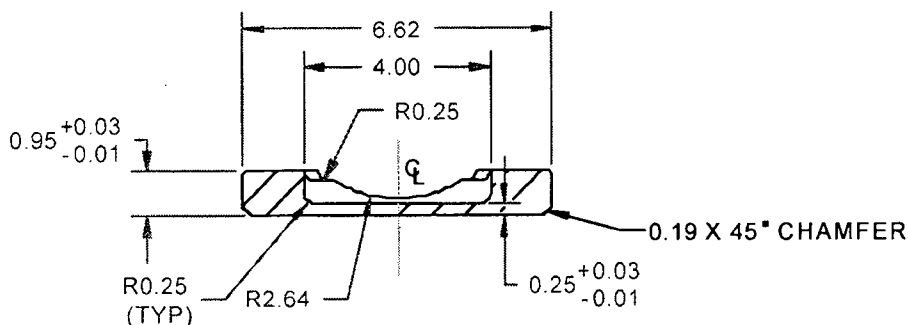
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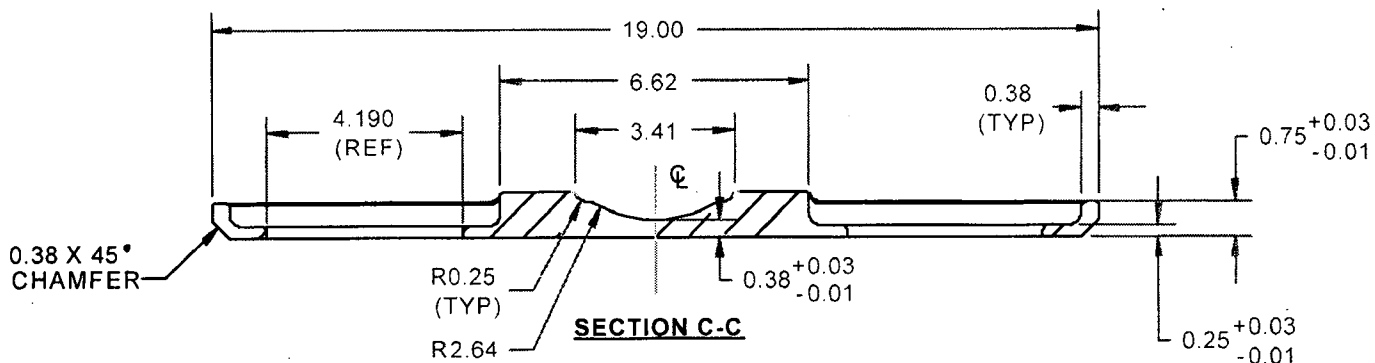
DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2521	REV. J  SHEET 3 OF 3
DATE 06.07.28		TITLE 205 BEARPAW	SCALE 1:4



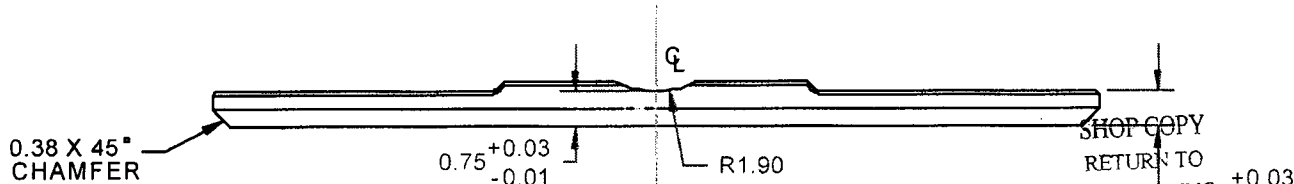
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

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WITHOUT NOTICE  
WORK ORDER  
NO. 35062

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Friday, 04/04/2008 2:47:06 PM

Melanie Fauteux

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: UPDATE PAPERWORK
Job Number	: 38417		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D205564011
This Issue	: 04/04/2008 S.O. No. :	Drawing Number	: ECN1170
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: <u>mf</u>	Due Date	: 11/04/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
PULL FROM STOCK  
D205-564-011 B \_\_\_\_\_



B35062 B36690  
B35062 B36690  
B35062 B32835  
B35062 B32835  
B35062 B32835  
B32835 B32835  
B32835 B32835  
B32835 B32835  
B36690  
B36690  
B36690

ADD TO KITS IN STOCK FAA STC SR00571NY  
FMS TO BE REINSTATED  
PER ECN1170

RETURN KITS TO STOCK

update completed  
(X17) 08/04/08

2.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



08/04/14

Job Completion



mf 08-04-10  
W

1941

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Date: Friday, 08/08/2008 11:36:54 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D205-564-011
Job Number	: 41078		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: DISASSEMBLE10
This Issue	: 08/08/2008 S.O. No. :	Drawing Number	: DISASSEMBLE
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 15/08/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE FROM STOCK:

1 X D205-564-011 B 35062

RETURN ITEMS TO STOCK:

→ 2 X D2521 B 35062 344.638 X D2182B055 B 34777 1.6320 X D2274 B 32857 1.1320 X D2529 B 32025 1.038 X D2947 B 30386 1.874 X D3544-041 B 35088 12.158 X AN4-13A B 106043 1.2820 X AN4-15A B 107746 1.2020 X AN960JD416 B 105906 1.0320 X MS21042L4 B 105054 1.17

ADJUST ACCPAC

8/8/8 50 (X)

Date: Friday, 08/08/2008 11:36:54 AM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D205-564-011

Job Number: 41078

Part Number: DISASSEMBLE10

Job Number:



Seq. #:

Machine Or Operation:

Description :

2.0

D205564011

Bearpaw



①

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bearpaw

8/8/8

50

3.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

08/08/11

Job Completion



*Handwritten signature: W. S. S. S.*